

FIG.2

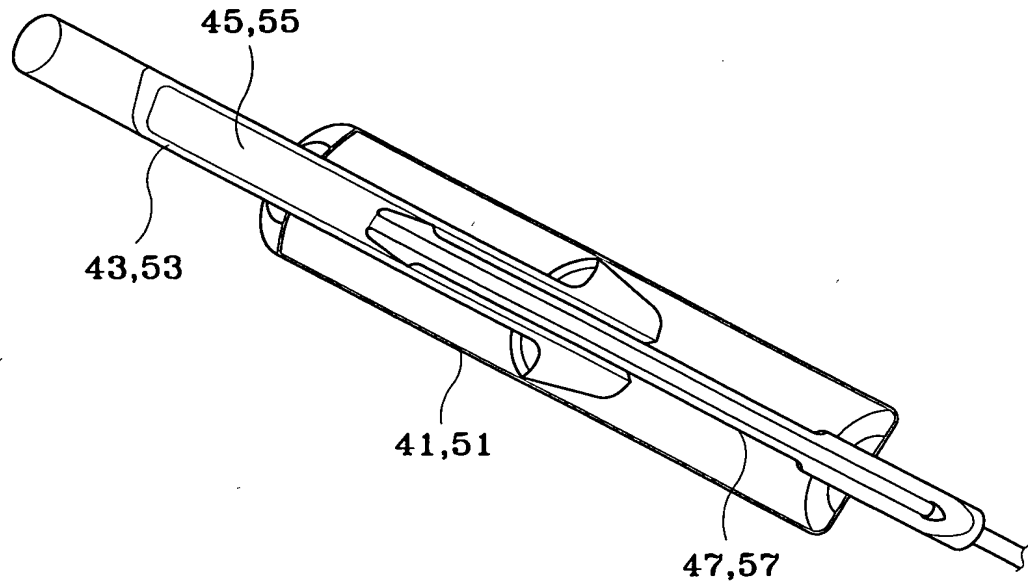


FIG.3

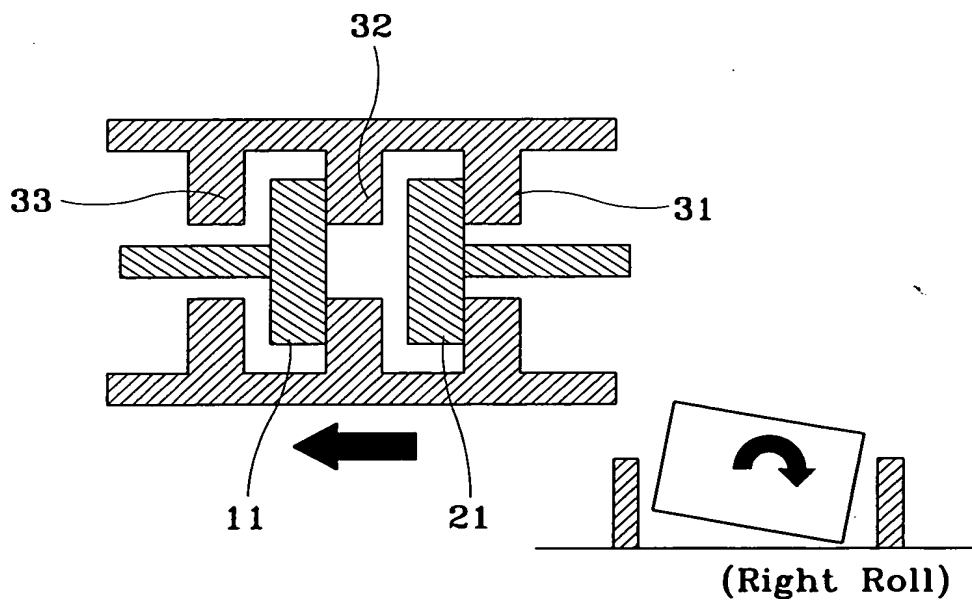


FIG.4

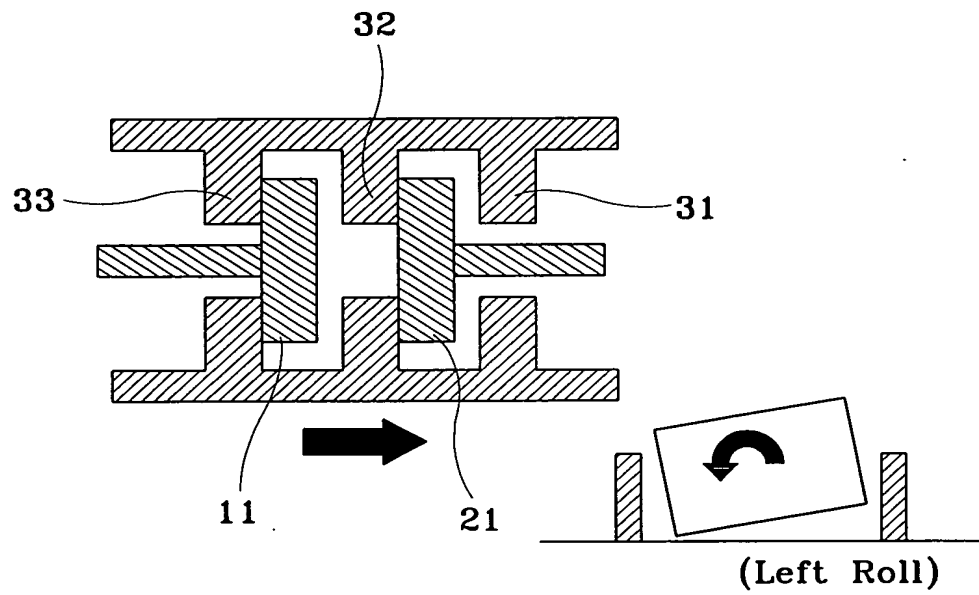


FIG.5

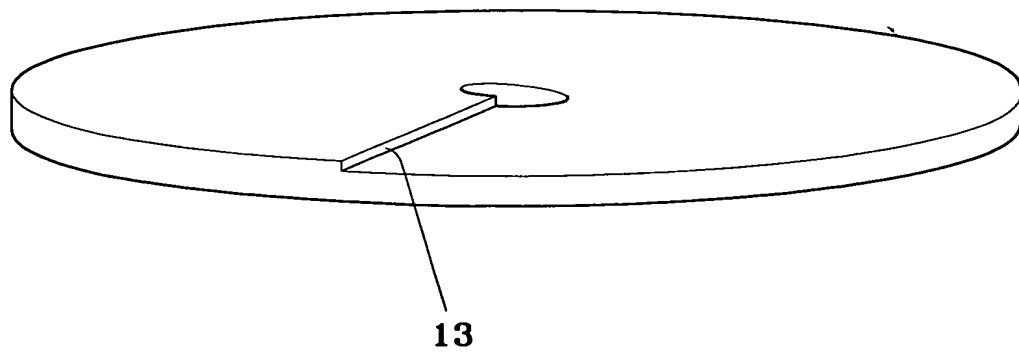


FIG.6

**GENERATION OF A ROLL EXCEEDING
A PREDETERMINED DEGREE**

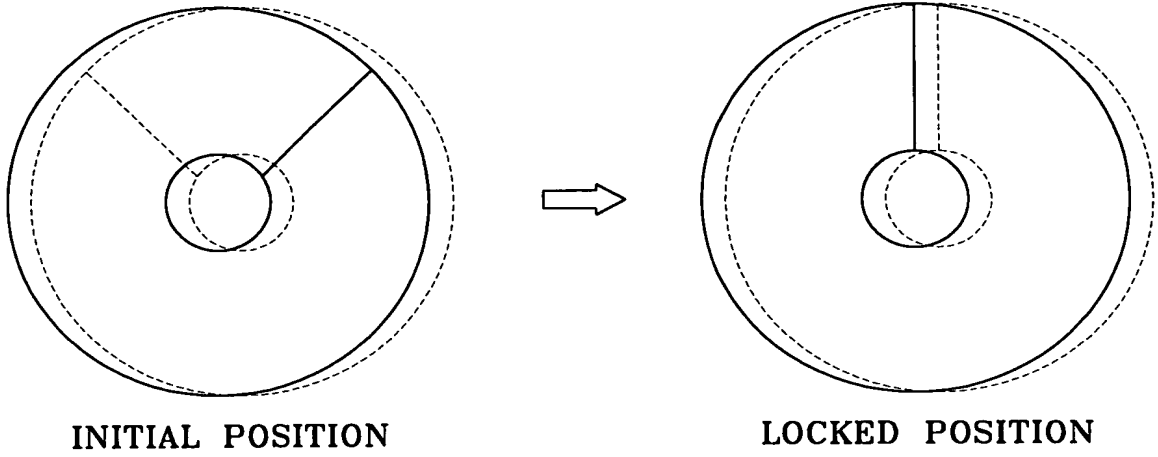


FIG. 7

